



DAR Aerospace Ltd.
 100 Aberdeen St
 Wexbury, ON
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 Canada
 Tel (613) 632-5200
 Fax 613 632-5246

RBW1805G01431-3G

Job Sheet 190176



Part No: RBW1805G01431-3G

Job Qty: 2 pcs

Part Name: AW139 Tool, Mast Vibration Absorber Remove/Install



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 2/5/19

Job Tracking No: SIOP

Due Date: 3/15/19

10/24/2019

Created By: Dara Macdonald

Type: Stock

Description:

Note: DWG RBW1805G01431-3G REV 0 IPP REV A 18.02.16 NEW ISSUE FK VERIFY DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
95	Small Fab - 1	2 pcs	3/15/19		0.00	0.00	Small Fab - 1		
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		GP 19-10-04
							Small Fab - 7		
100	Small Fab - 2 - B4B	2 pcs	3/15/19		0.00	2.00	Small Fab - 1 - B4B		
							Small Fab - 2 - B4B		
							Small Fab - 3 - B4B		
							Small Fab - 4 - B4B		
							Small Fab - 5 - B4B		
							Small Fab - 6 - B4B		GP 19-10-08
							Small Fab - 7 - B4B		
110	QC 5	2 pcs	3/15/19		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 38		
							QC 5 - 42		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		

DAS
40
9-88

OCT 0 8 2019

130 Packaging 3-1 - Stock - B4B 2 pcs	3/15/19	0.00 0.00	QC 5 - 30	
			Packaging 3 - 1 - B4B	
			Packaging 3 - 2 - B4B	
			Packaging 3 - 3 - B4B	
			Packaging 3 - 4 - B4B	
			Packaging 3 - 5 - B4B	DAS 28 9-89
			Packaging 3 - 6 - B4B	
			Packaging 3 - 7 - B4B	
			Packaging 3 - 8 - B4B	
			Packaging 3 - 9 - B4B	
			Packaging 3 - 10 - B4B	
			Packaging 3 - 11 - B4B	
			Packaging 3 - 12 - B4B	
			Packaging 3 - 13 - B4B	
			Packaging 3 - 14 - B4B	
			Packaging 3 - 15 - B4B	
			Packaging 3 - 16 - B4B	
			Packaging 3 - 17 - B4B	
			Packaging 3 - 18 - B4B	
			Packaging 3 - 19 - B4B	
			Packaging 3 - 20 - B4B	
			Packaging 3 - 21 - B4B	
			Packaging 3 - 22 - B4B	
			Packaging 3 - 23 - B4B	
			Packaging 3 - 24 - B4B	
			Packaging 3 - 25 - B4B	
			Packaging 3 - 26 - B4B	
			Packaging 3 - 27 - B4B	
			Packaging 3 - 28 - B4B	
			Packaging 3 - 29 - B4B	
			Packaging 3 - 30 - B4B	
			Packaging 3 - 31 - B4B	
			Packaging 3 - 32 - B4B	
			Packaging 3 - 33 - B4B	
			Packaging 3 - 34 - B4B	
			Packaging 3 - 35 - B4B	
			Packaging 3 - 36 - B4B	
140 QC 21 - FG 2 pcs	3/15/19	0.00 0.00	QC 21 - FG - 21	DAS 21 9-89
			QC 21 - FG - 70	
			QC 21 - SA - 53	

Part Op 95 - Small Fab - 1-Engrave placard RB41011 using marktronic engraver 2-Transfer drill Dart placard RB41011 into

Descriptions: Pelican# 1550NF 3-Debur holes and remove chips from case. 4-Rivet Dart placard to Pelican case 5-Glue placard RBW1805G01431-3G-11 to RBW1805G01431-3G-9 foam as per DWG. 6-Glue foam to case and pack case as per DWG.

100 - Small Fab - 1-Engrave placard RB41011 using marktronic engraver 2-Transfer drill Dart placard RB41011 into Pelican# 1550NF 3-Debur holes and remove chips from case. 4-Rivet Dart placard to Pelican case 5-Glue placard RBW1805G01431-3G-11 to RBW1805G01431-3G-9 foam as per DWG. 6-Glue foam to case and pack case as per DWG.

110 - QC5- Inspect part completeness to step on W/O

130 - Identify as per dwg & Stock Location: _____

140 - QC21- Final Inspection - Work Order Release

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9-89

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Job BOM

Part / Item	Component Name	Quantity	Operation	Container
APP-1550NF	Case	2 Ea (1 ea)	100-Small Fab - 2 - B4B	
RBW1805G01431-3G-7	Bottom Tool Cushion use in case APP-1550-NF	2 Ea (1 ea)	100-Small Fab - 2 - B4B	
RBW1805G01431-3G-9	Top Tool Cushion use in case APP-1550-NF	2 Ea (1 ea)	100-Small Fab - 2 - B4B	
RBW1805G01531-3G-PO	Mast Vibration Absorber Lifting Tool	2 pcs (1 ea)	100-Small Fab - 2 - B4B	
RBW1805G01631-3G	Mast Vibration Absorber Installation Tool	2 pcs (1 ea)	100-Small Fab - 2 - B4B	
RBW1805G01731-3G	Mast Vibration Absorber Removal Tool	2 pcs (1 ea)	100-Small Fab - 2 - B4B	
97524A032	Sealing Blind Rivet	8 Ea (4 ea)	100-Small Fab - 2 - B4B	
RB41011	Dart Tooling Placard, Aluminum	2 Ea (1 ea)	100-Small Fab - 2 - B4B	
RBW1805G01431-3G-11	Placard	2 pcs (1 ea)	100-Small Fab - 2 - B4B	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Small Fab - 2 - B4B	97524A032	8	221	0
	APP-1550NF	2	4	0
	RB41011	2	380	0
	RBW1805G01431-3G-11	2	5	0
	RBW1805G01431-3G-7	2	5	0
	RBW1805G01431-3G-9	2	5	0
	RBW1805G01531-3G	2	2	0
	RBW1805G01631-3G	2	0	0
	RBW1805G01731-3G	2	1	0

Part Specifications

Specifications could not be found.

Plex 3/13/19 3:52 PM dart.leclair.mathieu



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Job Sheet 190176



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Part Name: AW139 Tool, Mast Vibration Absorber Remove/Install



Part Weight: 0 lbs

Status: New

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Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Small Fab - 1	2 pcs	3/15/19		0.00	2.00	Small Fab - 1		
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
110	QC 5	2 pcs	3/15/19		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 38		
							QC 5 - 42		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
130	Packaging 3-1 - Stock - B4B	2 pcs	3/15/19		0.00	0.00	Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		

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				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
140 QC 21 - FG	2 pcs	3/15/19	0.00 0.00	QC 21 - FG - 21	
				QC 21 - FG - 70	
				QC 21 - SA - 53	

Part Op 100 - Small Fab - 1-Engrave placard RB41011 using marktronic engraver 2-Transfer drill Dart placard RB41011 into
 Descriptions: Pelican# 1550NF 3-Deburr holes and remove chips from case. 4-Rivet Dart placard to Pelican case 5-Glue placard
 RBW1805G01431-3G-11 to RBW1805G01431-3G-9 foam as per DWG. 6-Glue foam to case and pack case as per DWG.
 110 - QC5- Inspect part completeness to step on W/O
 130 - Identify as per dwg & Stock Location:
 140 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
APP-1550NF	Case 62F 008A	2 Ea (1 ea)	100-Small Fab - 1	5124774
RBW1805G01431-3G-7	Bottom Tool Cushion use in case APP-1550-NF	2 Ea (1 ea)	100-Small Fab - 1	5124776-79
RBW1805G01431-3G-9	Top Tool Cushion use in case APP-1550-NF	2 Ea (1 ea)	100-Small Fab - 1	5124775-78
RBW1805G01531-3G	Mast Vibration Absorber Lifting Tool 141E	2 pcs (1 ea)	100-Small Fab - 1	5115573
RBW1805G01631-3G	Mast Vibration Absorber Installation Tool 97F	2 pcs (1 ea)	100-Small Fab - 1	5115573
RBW1805G01731-3G	Mast Vibration Absorber Removal Tool 138A	2 pcs (1 ea)	100-Small Fab - 1	5115573
97524A032	Sealing Blind Rivet 40	8 Ea (4 ea)	100-Small Fab - 1	5163934
RB41011	Dart Tooling Placard, Aluminum ✓	2 Ea (1 ea)	100-Small Fab - 1	5021040
RBW1805G01431-3G-11	Placard 107	2 pcs (1 ea)	100-Small Fab - 1	5138090

RBW1805G01531-3G-XO

x2

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Small Fab - 1	97524A032	8	526	0
	APP-1550NF	2	2	0
	RB41011	2	425	0
	RBW1805G01431-3G-11	2	5	0
	RBW1805G01431-3G-7	2	3	0
	RBW1805G01431-3G-9	2	3	0
	RBW1805G01531-3G- <i>Reup</i>	2	3	0
	<i>✓</i> RBW1805G01631-3G	2	0	0
	RBW1805G01731-3G <i>Reup</i>	2	0	0
Part Specifications				
Specifications could not be found.				

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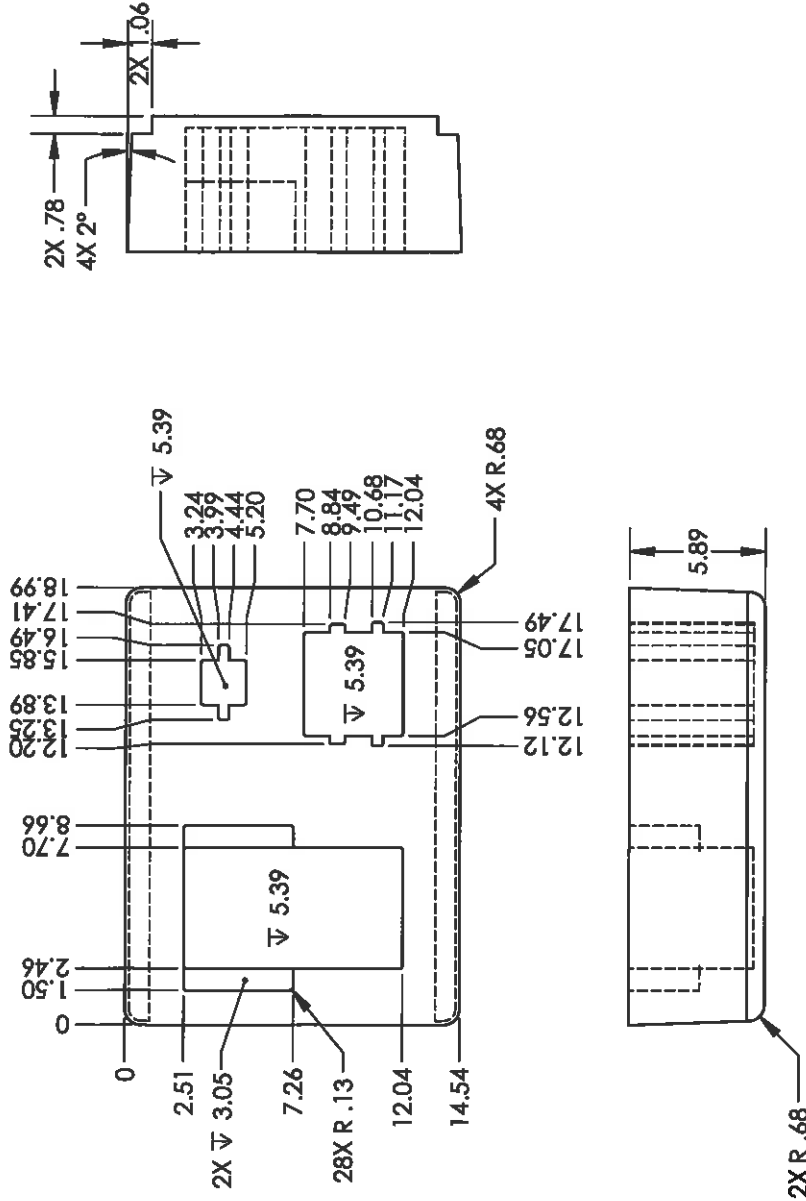
REVISIONS			
REV	DESCRIPTION	DATE	INITIAL APPROVED

RED BARN MACHINE									
TOOL KIT, MAST VIBRATION ABSORBER REM/INST									
TITLE									
DWG NO. RBW1805G01431-3G REV									
DRAWN BY: SMITH									
APPROVED <i>D. Wall</i>									
UNLESS OTHERWISE SPECIFIED									
DIMENSIONS ARE IN INCHES									
FRACTIONS $\pm 1/32$									
ANGLES $\pm .1^\circ$									
1. BREAK ALL SHARP EDGES .015 x .45"									
2. DIMENSIONAL LIMITS APPLY AFTER PLATING									
USED ON MODEL AW139									
SCALE 1:8 DATE 8/20/2013 SHEET 1 OF 4									
ASSY QTY	B/O	Part #	Default lt./QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.		
		-1	1	MVA LIFTING TOOL		RBW1805G01531-3G	1		
		-3	1	MVA INSTALLATION TOOL		RBW1805G01631-3G	1		
		-5	1	MVA REMOVAL TOOL		RBW1805G01731-3G	1		
		-7	1	BOTTOM TOOL CUSHION	Y20 BLACK	5.89 X 14.54 X 18.99	2		
		-9	1	TOP TOOL CUSHION	Y20 BLACK	1.79 X 14.34 X 18.75	3		
		-11	1	PLACARD	PLASTIC	1/16 X 4-1/8 X 6-1/8	4		
B/O		-13	1	CASE	PLASTIC	PELICAN #150DNF	N/S		
B/O		15	1	RED BARN PLACARD	ALUMINUM	RB41009	N/S		
B/O		-17	4	#2 DRIVE SCREW	COATED STEEL	1/8 McMaster-Carr #90081A074	N/S		

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REVISIONS

REV	DESCRIPTION	DATE	INITIAL	APPROVED
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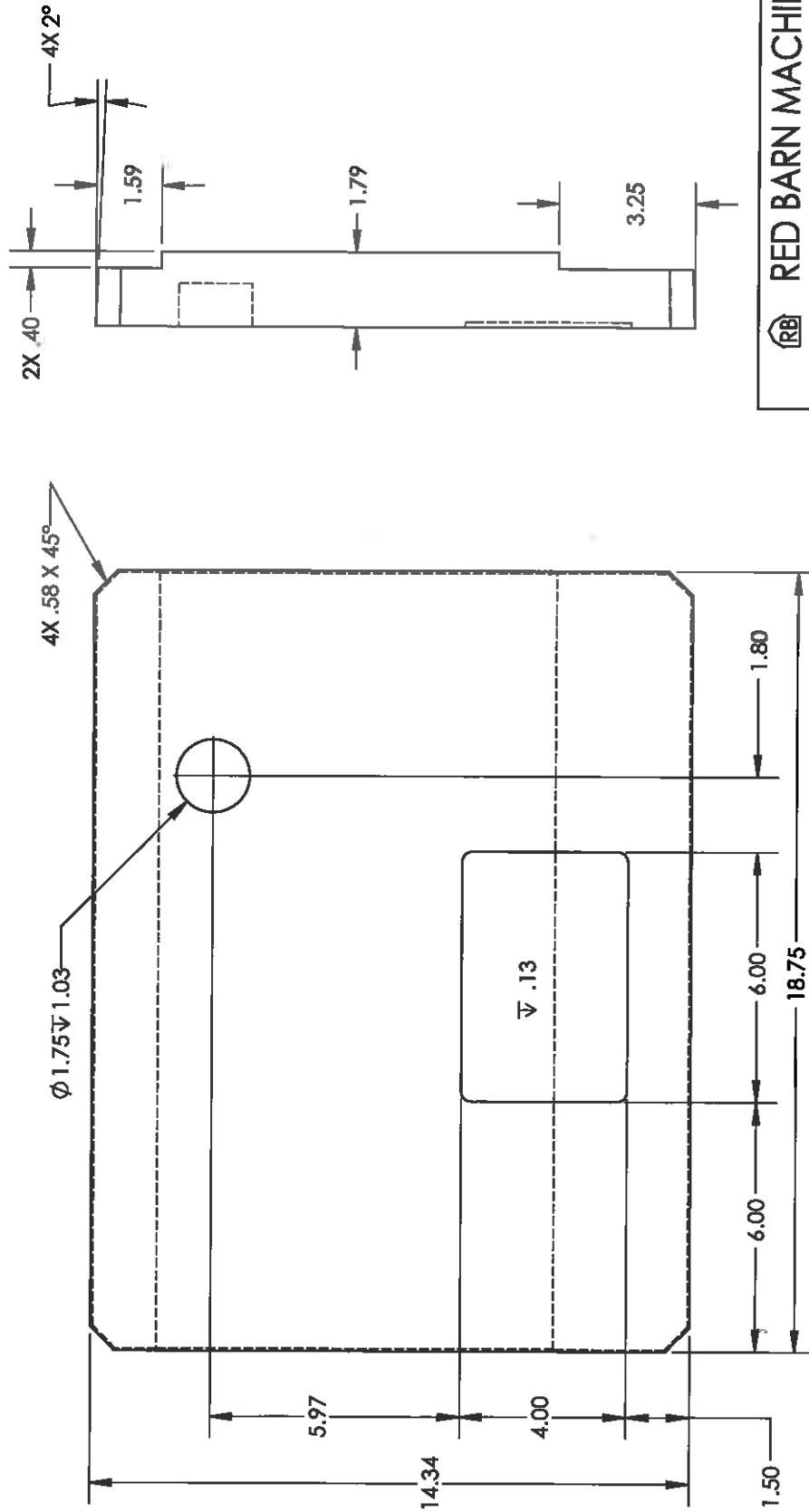


⑦
BOTTOM TOOL CUSHION

RED BARN MACHINE	
TITLE TOOL KIT, MAST VIBRATION ABSORBER REM/INST	
DWG NO. RBW1805G01431-3G-7	REV
DRAWN BY: SMITH	
APPROVED: <i>D. Smith</i>	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES FRACTIONS ± 1/32 DECIMALS ± .01 ANGLES ± 5° FINISH SPEC	
1. BREAK ALL SHARP EDGES .015 x 45° 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE 1:8	DATE 6/20/2013
SHEET 2 OF 4	

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REV		REVISIONS	
REV	DESCRIPTION	DATE	INITIAL



RED BARN MACHINE

TITLE		TOOL KIT, MAST VIBRATION ABSORBER REM/INST	
DWG NO.	RBW1805G01431-3G-9	REV	
MATL	Y20, BLACK	DRAWN BY:	SMITH
UNLESS OTHERWISE SPECIFIED		APPROVED	<i>D. West</i>
DIMENSIONS ARE IN INCHES		TEXT	
FRACTIONS $\pm 1/32$		TREAT	
ANGLES $\pm .5^\circ$		FINISH	
1. BREAK ALL SHARP EDGES .015 X 45°		SPEC	
2. DIMENSIONAL LIMITS APPLY AFTER PLATING		USED ON MODEL	AW139
SCALE	1:4	DATE	6/20/2013
		SHEET 3 OF 4	

(-9)
TOP TOOL CUSHION

APPROVED

90

RED BARN MACHINE

TOOL KIT, MAST VIBRATION ABSORBER REM/INST

150

FLIP

000000

27

1

2

ED ON MODEL

AW139

SHEETS

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DQA:

Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed:

Date: _____

Work Order update only ☐

Work Order: _____ Part No. RBW1805G01431-3G NCR No. _____		DISPOSITION Rework ☐ ☐ ☐ Scrap ☐ ☐ ☐ Use-as-is ☐ ☐ ☐ Suspected Unapproved ☐ ☐ ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ ☐ ☐ ☐ ☐ Machining ☐ ☐ ☐ ☐ ☐ Thermoforming ☐ ☐ ☐ ☐ ☐ Large Fab ☐ ☐ ☐ ☐ ☐		Cross tube ☐ ☐ ☐ ☐ ☐ Small Fab ☐ ☐ ☐ ☐ ☐ Finishing ☐ ☐ ☐ ☐ ☐ Composite ☐ ☐ ☐ ☐ ☐		Water Jet ☐ ☐ ☐ ☐ ☐ Prod. Eng. Coord. ☐ ☐ ☐ ☐ ☐ Rec/Store/Packaging ☐ ☐ ☐ ☐ ☐ Supplier ☐ ☐ ☐ ☐ ☐		Engineering ☐ ☐ ☐ ☐ ☐ Quality ☐ ☐ ☐ ☐ ☐ Other ☐ ☐ ☐ ☐ ☐	
Date: _____		Step #: _____		QTY Effective: _____		MRB (QS042) Approval <i>M. Lee</i> Feb 21, 2018					
Description Work Order Deviation				Disposition							
- Replace RB41009 Placard with RB41011 Placard - Replace McMaster 90081A074 Drive Screw with McMaster 97524A032 Rivet.				- This deviation is acceptable. - The drawings will be updated to reflect these changes. - The fit, form and function of the tool will be as originally intended.							
Root Cause				FAULT CATEGORY							
Environment	No Re-verification	Pressure/Forced	Temperature/Cure	Power Loss/Surge	Positioned Wrong						
Design	Operator	Bending	Set-up	Folio/Program	Outside Dimensions						
Doc/Data	Offset/Setup	Centre Not Concentric	BOM/Route	Grain	Over/Under tolerance						
Equip/Tooling	Supplier	Cracks	Broken/Damage/Defect	Weld	Part Incorrect						
Handling/Pre	Training	Crimp/Kink/Ripple/Wave	Inspection Incomplete/Unqualified	Wrong Stock Pulled	Part Lost/Missing						
Material	Use for Testing	Cuffs	Contamination	Out of Sequence	Part Moved						
Internal Transport	Poor Information	Crushing	Countersink	Off-set	Drawing						
Tribal Knowledge	Rushing	Heat Treat	Cut Too Short	Mislabeled	Finish						
LOA	Product Improvement	Wave/Twist in Tube	Instructions Incomplete/Unclear	Fit/Function	Misread						
Substation	Process Improvement	Marks/Chatter	Drill Holes	Misaligned/off center	Turning Sequence						
Past Expiry Date	Manufacturing Process										
Misidentified	Past Due										
OTHER: _____											